Work Orde June-12-13 9:16		2916		*102	916*						Page 1
Revision ID: Item Name:	D3562-041 Step Assembly 6/14/13 6/14/13	, LH Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*	Accept	*N900 Cust Item I Customer:		100)* s	etup Si	. 17	S1* S2*
Reference: Approvals:		n: <u>M</u> (ブ	Date: \\(\frac{13}{06} \)	3 Tooling: SPC (Y/N):		nte:		R		tart *N	R1* R2*
Sequence ID/ Work Center II	· ····································	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr		ision Nbr									
D3562	F									•	•
*100 *100* Large Fab Large Fab			2 extrusion as per Dwg D nd bevel ends for welding	0.00 0.00 3562				2	_\$		13.11.2
*110 *110* QC Quality Control		QC6- Inspect dimension	ns to drawing	0.00	13.11.2	7	· —	3 X	**		·- ·· •-
*120 *120*	·	Chemical Conversion C	Coat per QSI005 4.1	0.00				2	Z	G 131	7-30
HandFinish		Memo		0.00					•		

Hand Finishing

DQA:			Date:			MORK ORDER MON	~	NIFO		DATE					"DART
QA Closed:			Date:			WORK ORDER NON-	-CC	JNFOI	RIVIANCE / UPI		Wo	ork Order up	date only		AEROSPACE
144 a ml . O mal a						DISPOSITION	l			AGAINST	DE	PARTMENT	PROCESS		
Work Orde	er:					n a a el .	ı		Claid Author	C	\neg		Water let		Engineering
Part N	10					Rework Scrap			Skid-tube Machining	Crosstube Small Fab			Water Jet d. Eng. Coor.		Engineering Quality Other
NCR N	No					Use-as-is Suspected Unapproved		mem	noforming Large Fab	Finishing Composite		Rec/Stor	re/Packaging Supplier		Other
Root				-	Desci	ription of work order update		nitial	Actio	n		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	otion		Date	Verificatio	n	QC Inspector
Design											-				
Doc/Data															
Equip/Tooling															
Handling/Pre													į		
Material			!										:		
Operator															
Offset/Setup														ı	
Process															
Supplier							İ								
Training															
Transport															
Unapproved						<u>. </u>									
							FAI	ULT CA	TEGORY						
Landi	ng Gea	ar				General		_				_			
	Ве	ending				Bend		Folio/F	Program			Outside Dim	ensions		Pressure/Forced
	C€	entre No	t Concer	ntric		BOM/Route		Grain				Over/Under	tolerance		Set-up
,	Cr	acks				Broken/Damage/Defect		Hardwa	are			Part Incorred	ct		Temperature/Cure
	Cr	imp/Kir	ık/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unq	ualified		Part Lost/Mi	ssing		Weld
	cı	ıffs				Contamination		Instruct	tions Incomplete/Un	nclear		Part Moved			Wrong Stock Pulled
	∐ Cr	ushing				Countersink		Misalig	gned/off center			Positioned V	Vrong		
	Н	eat Trea	t			Cut Too Short		Mislabe	eled			Power Loss/	Surge		Other
	In	spection	n Strip in	Tube		Drawing		Misrea	d						
	Шм	arks/Ch	atter			Drill Holes		Off-set							
	[_]τι	irning S	equence			Finish		Out of	Calibration						
	1 7.	ave/Tw	ist in Tuk	20		Fit/Function		Out of	Saguanca						

Work Ord Jüne-12-13 9:		02916		*102	916*						Page
Item ID:	D3562-041			Accept	*N900	<u>040</u>	100)* s	etup Star	* *N	S1*
Revision ID: .Item Name:	Step Assemb	oly, LH							Stop	*N	S2*
Start Date: Required Dat	6/14/13 e: 6/14/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item I Customer:	D:					
Reference:							_	F	tun Star	t u ri	
Approvals:	Process P	lan:	Date:	Tooling: _	Da	ate:		-		171	R1*
••	QC:		Date:	SPC (Y/N):	Da	ate:	····		Sto	, *N	R2*
Sequence ID/ Work Center		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		QC3- Inspect Part Finish		0.00							(DA
130		Memo		0.00				_2_	<u> </u>		14.01

0.00

0.00

140 *140* Small Fab

Small Fab

Small Fab

Memo

1- Transfer drill Rivet holes as per dwg D3562.

2-Touch-up rivet holes with alodine as per dwg d3562

3-Rivet legs using Scotch-Weld as per dwg D3562.

******Ensure to wipe off any exess magnobond ******

A/R Scotch-Weld DP460
Batch: 12605
EXP DATE: 14.05.0

Page 2

DQA:	Date:											
QA Closed:		Date	:		WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE	w	ork Order up	odate only	AEROSPACE
	=:				DISPOSITION			a AGAINS		PARTMENT		
Work Orde	er:					.			_	, 1		-, -,
Part N	lo			_	Rework Scrap			Skid-tube Crosstube Machining Small Fal	_b	-	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	No	***************************************			Use-as-is Suspected Unapproved		Thern	noforming Finishing Large Fab Composite	-	Rec/Stor	re/Packaging Supplier	Other
Root	-			Desci	ription of work order update		nitial	Action		Sign &		
Cause	Dat	te Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design												
Doc/Data												
Equip/Tooling							-					
Handling/Pre												
Material							-	·				
Operator					•							,
Offset/Setup												
Process												
Supplier												
Training												
Transport												
Unapproved						1						
						FA	ULT CA	TEGORY				
Landi	ng Gear	•			General		_			_		
	Bend	ing			Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
	Centr	e Not Conce	entric		BOM/Route		Grain	•		Over/Under	tolerance	Set-up
	Crack	S			Broken/Damage/Defect		Hardwa	are		Part Incorre	ct [Temperature/Cure
	Crim	/Kink/Rippl	e/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		Instruct	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
	Crush	ing			Countersink		Misalig	gned/off-center		Positioned V	Vrong	•
	Heat	Treat			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
	Inspection Strip in Tube				Drawing		Misrea	d		· .		
	Mark	s/Chatter			Drill Holes		Off-set					
	Turni	ng Sequence	e		Finish		Out of	Calibration				
	Turning Sequence Wave/Twist in Tube				Fit/Function		Out of	Sequence				

Work Ord June-12-13 9:	der ID 10 16:40 AM)2916			*102	2916*						Page 3
Item ID: Revision ID: Item Name:	D3562-041 Step Assemb	ly, LH			Accept	*N900	040	100)* s	etup Sta Sto	1.71	S1* S2*
Start Date: Required Dat Reference:	6/14/13 e: 6/14/13	Start Qty: 2.00 Req'd Qty: 2.00	. *	*2* *2*		Cust Item I Customer:	D:					
Approvals:	Process Pl	an:	Date:		Tooling:	Da	ate:		R	tun Sta	17	R1*
i ippi o valor	QC:		Date:		SPC (Y/N):	D:	ate:			Sto	*N	R2*
Sequence ID/ Work Center		Operation Description		-	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*150 *150* QC		QC5- Inspect part com	npleteness to ste	p on W/O	0.00				2	14-0	1.09	DAS 9 9-89
Quality Control	ı											
160		Large Fab		,	0.00					D		M
160 Large Fab		Memo			0.00				_2_	<u>Ø</u>		14-01-0
Large Fab		per QSI 0 A/RAlum		3928	& QSI 004. Inspect for fo	reign objects as						17 01

DAS 27

0.00

QC10- Inspect visual per QSI004- ground welds

Memo

170

170

Quality Control

DQA:	Date:													
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UF		Wd	ork Order up	odate only		AEROSPACE
Work Orde	er:				DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
Part N	No				Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		1	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root				Descr	iption of work order update	ı	nitial	Act	ion		Sign &			
Cause	Dat	e Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption		Date	Verification	n	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved													,	
						FAI	ULT CA	TEGORY						
Landi	Landing Gear Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence			General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalia Mislaba Misreaa Off-set	ion Incomplete/Un tions Incomplete/U gned/off center eled d			Outside Dim Over/Under Part Incorre Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct issing Vrong		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other	
	Turning Sequence Wave/Twist in Tube				Fit/Function		1	Sequence						

,-												
Work Ordo June-12-13 9:10		2916		*102	916*						Page	4
Item ID: Revision ID: Item Name:	D3562-041 Step Assembl	y, LH		Accept	*N900	040	100)* s	etup Sta	I VI	S1* S2*	
Start Date: Required Date: Reference:	6/14/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item I. Customer:	D:						
Approvals:	Process Pla	an:	Date:	Tooling:		nte:	_	R	Run Sta	rt *N	R1*	
Approvais.		411.		_		ite:			Sto	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description QC5- Inspect part comp	leteness to step on W/O	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
180 QC Quality Control		Memo		0.00 9.89 \ \ \ \	۷			9	<u> </u>			_
190		Chemical Conversion C	oat per QSI005 4.1	0.00				7		<i>a</i>		
100 HandFinish Hand Finishing		Memo		0.00				4_	- He	<u> 17</u>	ho [~]	4

200

200 Powdercoat

Powder Coating

Memo

White Gloss(Ref:4.3.5.1) per QS1005 13 Alume ...

0.00

START TIME: OVEN TEMPERATURE: FINISH TIME:

0.00

2 6 14-1-13.

DQA:			Date:										
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UI		Vork Order up	odate only	AEROSPACE
						DISPOSITION		-		AGAINST D	EPARTMENT	/PROCESS	
Work Orde	er: _						.			7.675	-	_	, <u> </u>
						Rework			Skid-tube	Crosstube	_	Water Jet	Engineering
Part N	۷o. ِ					Scrap			Machining	Small Fab	→	d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	No.					Suspected Unapproved			Large Fab	Composite		Supplier	ا لــا
Root					Desci	ription of work order update		nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Design													
Doc/Data			1										
Equip/Tooling													
Handling/Pre	Ш												
Material	Ш												
Operator	Ш												
Offset/Setup	Ш						1				1		
Process													
Supplier	\sqcup		İ										
Training				1									
Transport	Ш												
Unapproved			<u> </u>										
							FAI	ULT CA	TEGORY				
Landi		1				General		1		г			٦
	-	Bending	_		<u> </u>	Bend		1	Program	-	Outside Dim	<u> </u>	Pressure/Forced
	-	Centre No	ot Concei	ntric	-	BOM/Route	<u> </u>	Grain		-	Over/Under	⊢	Set-up
		Cracks		4	-	Broken/Damage/Defect		Hardwa			Part Incorre	}	Temperature/Cure
	-	Crimp/Kir	nk/Ripple	e/Wave	-	Burrs	_	1 '	ion Incomplete/Ur	· -	Part Lost/M	issing	Weld
		Cuffs			<u> </u>	Contamination	_	4	tions Incomplete/l	Jnclear	Part Moved	L	Wrong Stock Pulled
	$\overline{}$	Crushing			-	Countersink		1	gned/off center		Positioned V		٦
	Heat Treat			- 1	<u> </u>	Cut Too Short	\vdash	Mislabe		L	Power Loss/	Surge	Other
	Inspection Strip in Tube			Tube		Drawing	\vdash	Misrea					
	\vdash	Marks/Ch			 	Drill Holes	\vdash	Off-set					
		Turning Sequence Wave/Twist in Tube				Finish	<u></u>	4	Calibration -				
	1 1	ıWave/Tw	ust in Tul	ne -	i	Fit/Function	1	IOut of	Sequence				

Work Ord June-12-13 9:1)2916		*102	916*				Page	5
Item ID: Revision ID: Item Name:	D3562-041 Step Assemb	oly, LH Start Qty: 2.00	*2*	Accept	*N900040	100*	Setup	Start Stop	*NS1* *NS2*	
Start Date: Reguired Date Reference:		Req'd Qty: 2.00	*2*		Cust Item ID: Customer:					·
Approvals:		lan:	Date:	Tooling: SPC (Y/N):	Date:		Run	Start Stop	*NR1* *NR2*	
Sequence ID/ Work Center I 210 *210* HandFinish Hand Finishing	ID	Operation Description Wing Walk as per dwg QS Memo	51005 4.4 Batch MM	Set Up/ Run Hours	Tool ID Tool #	Plan Acc Code Qty	y Qt		Reject Insp. Number Stamp	>
220 * 77 * QC Quality Control		QC3- Inspect Part Finish Memo		0.00		2	×		14/0)	/DAS 36 //\$9-89
230 *230* Packaging Packaging		Identify as per dwg & Sto Memo	the Location: 6.49	0.00 1 7 0.00		2			14/6	DAS 36 0/ /9389

Packaging

DQA:			Date:										
QA Closed:			Date:			WORK ORDER NON	-CC	ONFO	RMANCE / UPDA		ork Order up	date only	AEROSPACE
						DISPOSITION			A	AGAINST DE	PARTMENT/	PROCESS	
Work Orde	er: -				_	P a a ul	1		Child Andrea		1	Water Jet	Engineering
Part i	No					Rework Scrap Use-as-is			Machining Si	rosstube mall Fab inishing	-{	d. Eng. Coor.	Quality Other
NCR f	No					Suspected Unapproved]		· H	mposite]	Supplier	
Root					Desci	ription of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descriptio	n	Date	Verification	QC Inspector
Design										-			
Doc/Data													
Equip/Tooling				•									
Handling/Pre									·				
Material		1											
Operator													
Offset/Setup													
Process							1						
Supplier			l										
Training	П												
Transport												:	
Unapproved	П												
							FA	ULT CA	TEGORY				
Landi	ng G	ear				General		_			_		
		Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
		Centre No	ot Conce	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	ct	Temperature/Cure
	П	Crimp/Kir	nk/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Unqual	lified	Part Lost/Mi	ssing	Weld
	Crimp/Kink/Ripple/Wave Cuffs			Contamination		Instruc	tions Incomplete/Uncle	ar	Part Moved		Wrong Stock Pulled		
	Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong		
		Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	Surge	Other
	Inspection Strip in Tube				Drawing	Г	Misrea	d					
	Marks/Chatter				Drill Holes		Off-set						
	Turning Sequence					Finish		Out of	Calibration				
	$\overline{}$	Turning Sequence Wave/Twist in Tube				Fit/Function		Out of	Sequence				

		-		
Want	Onda	~ ID	10291	6
WUFK	Orue	uu	10471	·U

Quality Control

102916

Page 6

June-12-13 9:1	6:40 AM											
Item ID: Revision ID:	D3562-041			Accept	*N900	040	100)* s	etup	Start Stop		S1*
Item Name:	Step Assem	bly, LH								Stop	*N:	S2*
Start Date: Required Date	6/14/13 : 6/14/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item I Customer:	D:						
Reference:								D	tun	Start	.1. 8	— 4.4.
Approvals:	Process P	lan:	Date:	Tooling:	D:	ate:		N			*N	R1*
	QC:		Date:	SPC (Y/N):	D	ate:				Stop	*N	R2*
Sequence ID/ Work Center I	(D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
240 *240*		QC21- Final Inspection	- Work Order Release	0.00					,	W 1	21-0	1-15
QC		Memo		0.00					/	E. V		

DQA: Date:			WORK ORDER NON-CONFORMANCE / UPDATE									DART.			
QA Closed: Date:						WORK ORDER NON-CONFORMANCE / OPDATE Work Order update only									AEROSPACE
Work Order:						DISPOSITION AGAINST DE					DEPARTMENT/PROCESS				
WOIK OIGE						Rework			Skid-tube	Crosstube			Water Jet	η,	Engineering
Part N	do.					Scrap		l.	Machining	Small Fab	\dashv	Prod. Eng. Coor.			Quality
						Use-as-is			noforming	Finishing	\neg		e/Packaging	1	Other
NCR No.			Suspected Unapproved			Large Fab	Composite	\dashv	,	Supplier	7				
															<u> </u>
Root					Desci	ription of work order update	1	nitial	Act	ion		Sign &	,		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription		Date	Verification	\bot	QC Inspector
Design									!						
Doc/Data															
Equip/Tooling											İ				:# _
Handling/Pre															•
Material	Ш														•
Operator						*									
Offset/Setup	Щ														
Process							1				İ				
Supplier															
Training							1							-	
Transport							İ							-	
Unapproved				<u> </u>	<u> </u>		<u> </u>		<u> </u>						
		-					FA	ULT CA	regory						
Landi	ng Gea					General]		ı		la a.	. г	٦.	/e .
		nding			-	Bend	<u> </u>	1	Program			Outside Dim	<u> </u>		essure/Forced
	\vdash		t Conce	ntric		BOM/Route	-	Grain		ļ		Over/Under	<u> </u>	-	et-up
	$oldsymbol{oldsymbol{ o}}$	icks		4	<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa		116		Part Incorre		\dashv	emperature/Cure
	-		k/Ripple	e/Wave	_	Burrs	<u> </u>	- 1	ion Incomplete/Ur	1		Part Lost/Mi	ssing		/eld
	Cuffs			Contamination	<u></u>	4	tions Incomplete/U	Jnclear		Part Moved	<u>L</u>	\w	rong Stock Pulled		
	_	shing			<u> </u>	Countersink	\vdash	-1	ned/off center			Positioned V		コ。	41
	⊢	at Trea		~ .	 	Cut Too Short	<u> </u>	Mislabe				Power Loss/	Surge [10	ther
			Strip in	Tube	<u> </u>	Drawing	\vdash	Misrea							
	\vdash	arks/Ch			-	Drill Holes	\vdash	Off-set							
	$\overline{}$		equence ist in Tul		-	Finish Fit/Function	\vdash	-1	Calibration						
1	1 177	ave/ I Wi	ıstın iül	ue .		TEIL/ FUNCTION	1	TOUT Of 3	Sequence						

Picklist Print

June-12-13 9:16:39 AM

Work Order ID:

102916

Parent Item:

D3562-041

Parent Item Name:

Step Assembly, LH

Start Date: 6/14/13

Required Date: 6/14/13

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:A IPP rev B New Issue 06-11-09 JLM

ECN 987 07.1

07.10.09 EC verified by: DD

IPP Rev:C ECN1048 07-12-18 DD verified by:ec

IPP Rev:D 08-07-28 add chemical conversion coat DD verf:EC IPP REV:E 13.06.03 PER DWG

REV.F DD VERF:JLM

	REV.F DD VERI												
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No			100	Each	116.5700	1	2	1413	·11.2.	Z
Step Extrusion				8	101765	\widehat{A}	-		-		1010		<i>T</i>
	•			Location B	105575 =	<u> </u>	<u>L</u>	oc Code		9			
				WA0 <u>03 D</u>		116.57				<u> </u>			
		•		897		8.77							
				980		2.8							
				997	789	101					11		
D2734		Manufactured	No			140	Each	196.0000	2	4	1/9 1/2	1.01-	09
Step End Plate									· ——		-7-	<u></u>	<u> </u>
				Location R	105712	Loc Qty	<u>L</u>	oc Code	,	1			
										t			
•					1124	18			-		•		
				WA003	2618	178 156							
					682	6							
				84:		10							
				91	761	6					1	/	
D3560-041		Manufactured	No			140	Each	1.0000	1	2	15	13.12	2.23
Arm Weldment									(-1, , , , , , , , , , , , , , , , ,		-/ -	10,10	
				Location	100017	Loc Oty	<u>I</u>	oc Code		2			
					108017					2_		N	
				10	0382	140	Da.sh	o oòoo			. /	//	
D3560-043		Manufactured	No		, , ,	140	Each	0.0000	1	2	21	13.10	2.23
Arm Weldment				7	5103448	ろたつし							

DQA: Date:			~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~											
		D.4.			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only Work Order update only									
QA Closed:		Date:	.,		<u> </u>	_			VV	ork Order up	date only			
Work Order	•				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS			
Work Oraci	•				Rework	1		Skid-tube	Crosstube	Water Jet Engineering				
Part No) .				Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
					Use-as-is			noforming	Finishing	4	re/Packaging	Other		
NCR No	o .				Suspected Unapproved			Large Fab	Composite		Supplier			
						,								
Root				Desc	ription of work order update		Initial	Act	ion	Sign &				
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	QC Inspector		
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre	_													
Material	_							1						
Operator	_ .													
Offset/Setup														
Process	_							1						
Supplier	┧ .		Ì											
Training	_					1								
Transport	_		ł			l								
Unapproved				L		<u> </u>				<u> </u>	<u> </u>			
						FA	ULT CA	TEGORY						
Landing	 1			r	General	г	7 /		_	٦,	. г	7. /.		
<u> </u>	Bendin	•		-	Bend	-	-	Program	<u> </u>	Outside Dim	 -	Pressure/Forced		
-		Not Conce	ntric	-	BOM/Route	-	Grain		<u> </u>	Over/Under	 	Set-up		
-	Cracks	with the sale	- /\41	\vdash	Broken/Damage/Defect	\vdash	Hardwa			Part Incorre	- -	Temperature/Cure		
		Kink/Ripple	e/wave	-	Burrs	-	⊣ `	ion Incomplete/Ui	<u> </u>	Part Lost/M	issing	Weld		
-	Crushin	.~		-	Countarion	-	-	tions Incomplete/l	-	Part Moved Positioned V	L Mrong	Wrong Stock Pulled		
-	Crushir	_		-	Countersink Cut Too Short	\vdash	Mislab	gned/off center	<u> </u>	Positioned v		Other		
	Heat Ti	reat tion Strip in	Tubo	\vdash	Drawing	-	Misrea		L_	Trower ross/	ouige [Jouren		
-	 -	lion Strip in Chatter	ilube	\vdash	Drill Holes		Off-set							
	 -	g Sequence		-	Finish	\vdash	-1	Calibration						
-		Twist in Tul			Fit/Function	\vdash	-	Sequence						
					1		1							

June-12-13 9:16:39 AM

Work Order ID:

102916

Parent Item:

Blind Rivet

D3562-041

Parent Item Name: MS20600-AD4W5

Step Assembly, LH

Purchased

No

ST311

Start Date: 6/14/13

Required Date: 6/14/13

Start Qty: 2.00

1,052.0000

Required Qty: 2.00

M14.01.08

64

Loc Oty Loc Code Location

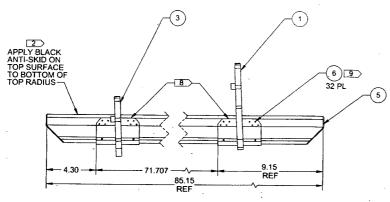
160

Each

1052 340 125654 712 m125709

DQA:	QA: Date:				TRACE								
QA Closed:	A Closed: Date:					WORK ORDER NON-	AEROSPACE						
······································						DISPOSITION					Vork Order up	· · · · · · · · · · · · · · · · · · ·	
Work Orde	er: _									-			
						Rework			Skid-tube	Crosstube	_	Water Jet	Engineering
Part N	۱o					Scrap	-		Machining	Small Fab	_	d. Eng. Coor.	Quality
NCR N	No.					Use-as-is Suspected Unapproved			noforming Large Fab	Finishing Composite	- Rec/Stoi	re/Packaging Supplier	Other
	-						'			, <u>L</u>			
Root			<u> </u>		Desc	ription of work order update	ı	nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling	Ш	•											
Handling/Pre													İ
Material			}			:							
Operator													
Offset/Setup													
Process	\Box										i		
Supplier													•
Training	Ш						l						
Transport	Ш											İ	
Unapproved			<u> </u>		<u> </u>		<u>L</u>			<u> </u>			
						· · · · · · · · · · · · · · · · · · ·	FAI	ULT CAT	TEGORY				
Landi						General	_	1 .		_	¬ '	_	
		Bending			<u> </u>	Bend		1 '	rogram	-	Outside Dim	<u> </u>	Pressure/Forced
	Н	Centre N	ot Conce	ntric		BOM/Route		Grain		1	Over/Under		Set-up
	⊢⊣	Cracks	_		-	Broken/Damage/Defect	<u> </u>	Hardwa			Part Incorre) —	Temperature/Cure
	-	Crimp/Kii	nk/Ripple	/Wave	 	Burrs	<u> </u>	1 '	ion Incomplete/Ur	·	Part Lost/M		Weld
	\vdash	Cuffs			\vdash	Contamination	<u> </u>	ł	ions Incomplete/U	Jnclear	Part Moved	L	Wrong Stock Pulled
	\vdash	Crushing			\vdash	Countersink	<u></u>	1	ned/off center	-	Positioned \		٦
•	-	Heat Trea			<u> </u>	Cut Too Short	<u></u>	Mislabe		į	Power Loss/	Surge	Other
	-	Inspectio		Tube	<u> </u>	Drawing	\vdash	Misrea		į,			
	-	Marks/Ch			<u> </u>	Drill Holes	\vdash	Off-set		- .			
	-	Turning S			<u> </u>	Finish	<u></u>	4	Calibration				***
	Wave/Twist in Tube			st in Tube									

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH



MEASURED BEFORE END CAPS WELDED IN PLACE

FWD'

D3562-041 LH STEP ASSEMBLY

NOTES:

D

1) MATERIAL: N/A

1) MATERIAL. 1974
2) FINISH:

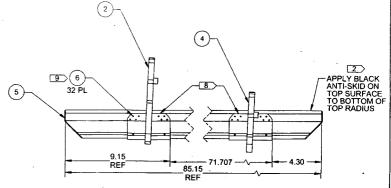
i) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR
GREY SANDTEX (4.3.5.6) OR
BLACK SANDTEX (4.3.5.7) OR
GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

ii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 8.79 IBS
8) INSTALL ARM WELDMENTS WITH A LAYER OF SCOTCH-WELD DP460 BETWEEN
THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH
SCOTCH-WELD DP460. CLEAN OFF EXCESS BEFORE POWDER COATING.
9) TRANSFER DRILL #30 DEBURR & TOUCH UP HOLES WITH CHEMICAL
CONVERSION COAT BEFORE RIVETING

102916 MLJ 1306-13

TEM No.	-041	QTY -042	P/N	DESCRIPTION				
	X		D3562-041	LH STEP ASSEMBLY				
		Х	D3562-042	RH STEP ASSEMBLY				
1	1		D3560-041	ARM WELDMENT				
2		1		ARM WELDMENT				
3	1			ARM WELDMENT				
4		1	D3560-044	ARM WELDMENT				
5	1	1	D3562-1	STEP ASSEMBLY				
6	32	32	MS20600AD4W5	RIVET				



MEASURED BEFORE END CAPS WELDED IN PLACE

FWD	
	RELEASED 2013 -06- 03

D3562-042 RH STEP ASSEMBLY

F	REVISED NOTE 8 TO REMOVE MAGNOBOND, REPLACE WITH SCOTCH-WELD DP460, REF. PAR12-224, ADDED NOTE 9 AND SHEET 2	DW	13.05.15
E	ADD QTY(2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2808 SPACER NOTE; REDRAW IN SOLIDWORKS	ÒС	07.11.16
С	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
В	ARMS NOW RIVETED TO STEP	CP	07.01.15
Α	NEW ISSUE	CP	06.09.26
REV.	DESCRIPTION	BY	DATE

	_	DECOUNT HOM		DA12				
DESIGN	a	DART AEROS	SPACE LT	Ď				
DRAWN	20	HAWKESBURY, ONTARIO, CANADA						
CHECKED	-GP	DRAWING NO.		REV. F				
MFG. APPR.	N.	D3562		SHEET 1 OF 2				
APPROVED		TITLE		SCALE				
DE APPR.	4	STEP ASSEMBLY		NŢS				
DATE 13.0	5.15	COPYRIGHT © 2006 BY DART AEROSPACE LTD THE DOCUMENT IS SHIMATE AND CONFERENCE AND IS SUPPLED ON THE DEPRESS CONTRICT IN THE TOTAL OF ITS SUPPLED ON THE DEPRESS CONTRICT IN THE MOST TO SELECTION AND PROPOSE OF COORDINATION AND THE PROPOSE OF COORDINATION OF THE PROPOSE OF COORDINATION OF THE PROPOSE OF COORDINATION OF THE PROPOSE OF T						

